

## Process Sheet

Date: Wednesday, 5/23/2007 3:43:15 PM  
 ser: Kim Johnston

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : TOW RING  
 Job Number : 32503  
 Estimate Number : 10400  
 P.O. Number : *N/A*  
 This Issue : 5/23/2007 S.O. No. : *N/A*  
 Prsht Rev. : NC  
 First Issue : *N/A* Type : MACHINED PARTS  
 Previous Run : 30275  
 Written By :  
 Checked & Approved By : *07.05.24*  
 Comment : Est: C 03.04.11 Reformat; Incorporated D2968-1/-5 KJ/RF

Part Number : D2968043  
 Drawing Number : D2968  
 Project Number : N/A  
 Drawing Revision : B1  
 Material : *N/A*  
 Due Date : 6/30/2007 Qty: *30* Um: *8* Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 32503A STEM



Comment: Sub-Component STEM  
 D2968-3 B *32503 A*

*FC*

2.0 32503B RING



Comment: Sub-Component RING  
 D2968-5 B *297910 x 14*

*030275 B x 16*

*Fe*

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D2968-3 & D2968-5 as per Dwg D2968 & QSI 004 using 4130 welding rod Identify as D2968-043

Batch: *m102 226*

*FC 07/06/25*

*(30)*

4.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*07/06/25 (30)*

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*07/06/25 (30)*

6.0 OUTSIDE SERV.30 OUTSIDE SERVICES-MACH



Comment: Sub-Contracting PURCHASING

Issue P/O: *4038*

Description: D2968-043 to heat treat to ultimate tensile strength

125ksi as per Dwg D2968

Conformity sheet required

*07/06/25*

*(30)*

*(30)*

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOW RING

Job Number: 32503

Part Number: D2968043

Job Number:



Seq. #:

Machine Or Operation:

Description:

Issue P/O: 4039  
Cad Plate per QQ-P-416F Class I Type II  
Conformity sheet required

07/06/25

(30)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Receive & Inspect For Transit Damage  
Ensure certificate of conformity is attached

07/07/25 (8)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/07/26 (8)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3  
\*\*\*DO NOT POWDER COAT THREADS\*\*\*

Unpainted

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

stock unpainted

07/07/27 (8)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

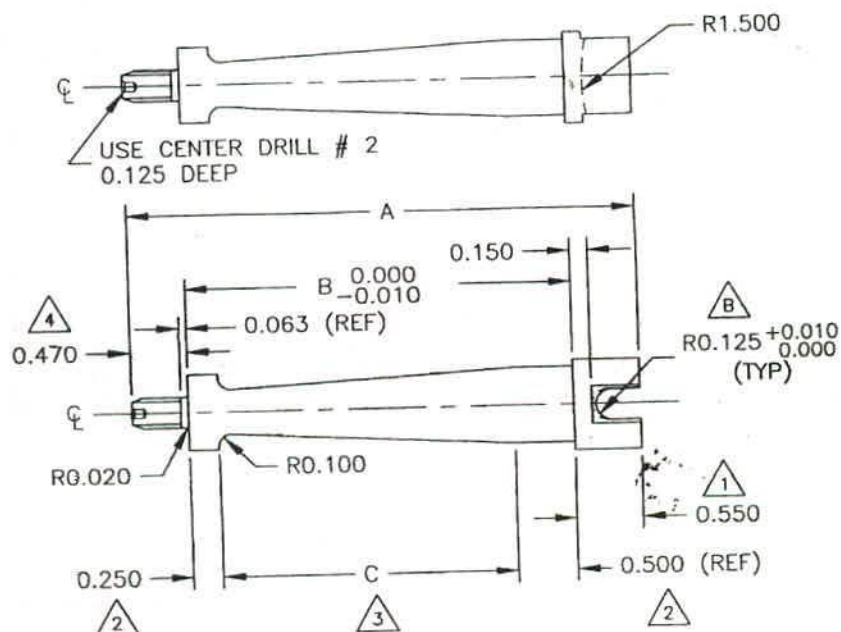
07/07/27 (8)

Job Completion



07/07/27





PART NUMBER	A	B	C
D2968-1	5.040	4.020	3.270
D2968-3	4.200	3.180	2.430

D2968-1/-3 STEM

D2968-1 AND D2968-3 STEM:

MATERIAL: AISI 4130

△ Ø0.750 O.D.

△ Ø0.625 O.D.

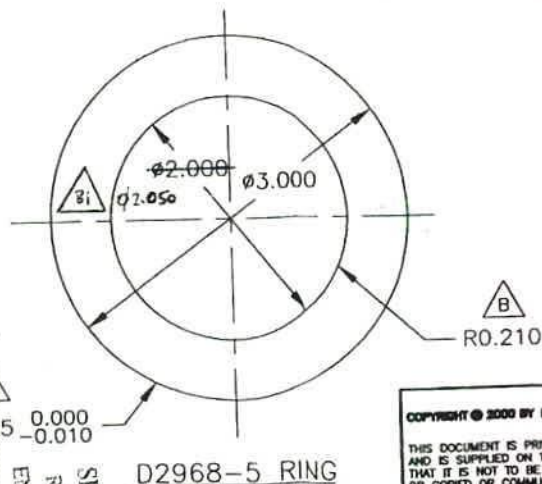
△ MACHINE UNIFORM TAPER FROM Ø0.363 O.D. TO Ø0.625 O.D.

△ 1/4-28 UNF THREAD WITH 0.063 GRIP MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS UNLESS OTHERWISE INDICATED TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2968-5 RING:

MATERIAL AISI 4130

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

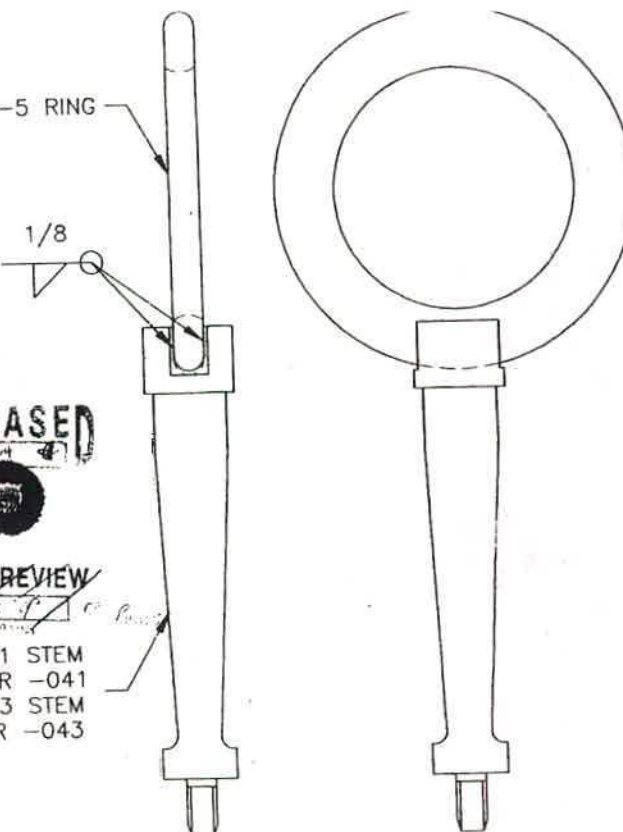


D2968-5 RING

RELEASED

UNDER REVIEW

USE 2968-1 STEM  
FOR -041  
USE 2968-3 STEM  
FOR -043



D2968-041 AND D2968-043 TOW RING:

WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING  
HEAT TREAT TO MIN ULTIMATE TENSILE STRENGTH OF 125 KSI  
FINISH: CAD PLATE ENTIRE ASSEMBLY PER

QQ-P-416F CLASS I TYPE II

POWDER COAT WHITE (REF 4.3.5.2) PER DART

QSI 005 4.3 (EXCEPT THREADS)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

B	00.05.31	R0.125 AND R0.210 WERE 0.060 x 45°
A	00.03.07	NEW ISSUE
DESIGN	RF	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2968
DATE	00.05.31	TITLE TOW RING

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